

Date: Tuesday, 30/09/2008 8:55:26 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 42351			Part Number	: D35371	
Estimate Number	: 12712			Drawing Number	: D3537 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 30/09/2008		S.O. No.	:		
Prsh Rev.	: NC			Drawing Revision	: C	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 42235			Material	:	
Written By	:			Due Date	: 15/10/2008	
Checked & Approved By	: JUL 08 9.30			Qty:	20	Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
		Comment: Qty.: 0.1113 sf(s)/Unit Total : 2.2260 sf(s) M304S16GA .063" 304 SS SHEET Batch: 109057 RB 8-10-27
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C RB 8-10-27 Prog Rev: C
		Comment: 2-Deburr if necessary RB 8-10-27
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC.	NC BRAKE
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:55:26 AM
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Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat m109303

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

EL 8-11-11 v20

7.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Job 11-11-20



Comment: VISUAL INSPECTION OF GROUND WELDS

8.0 QC5

INSPECT WORK TO CURRENT STEP



Job 11-11-20



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M106442



20X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:15

of

OVEN TEMPERATURE: 320

10:45

FINISH TIME:

m-1 08/11/13

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-13 20X

11.0 PACKAGING 1

PACKAGING RESOURCE #1



20X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

FP - 17

m-1 08/11/13

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/14 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42361
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

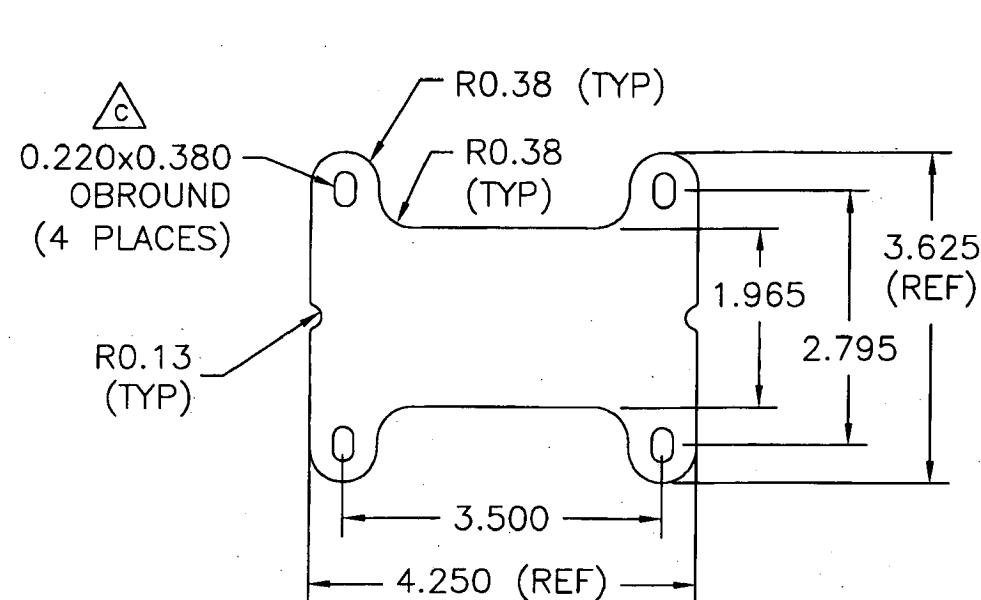
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

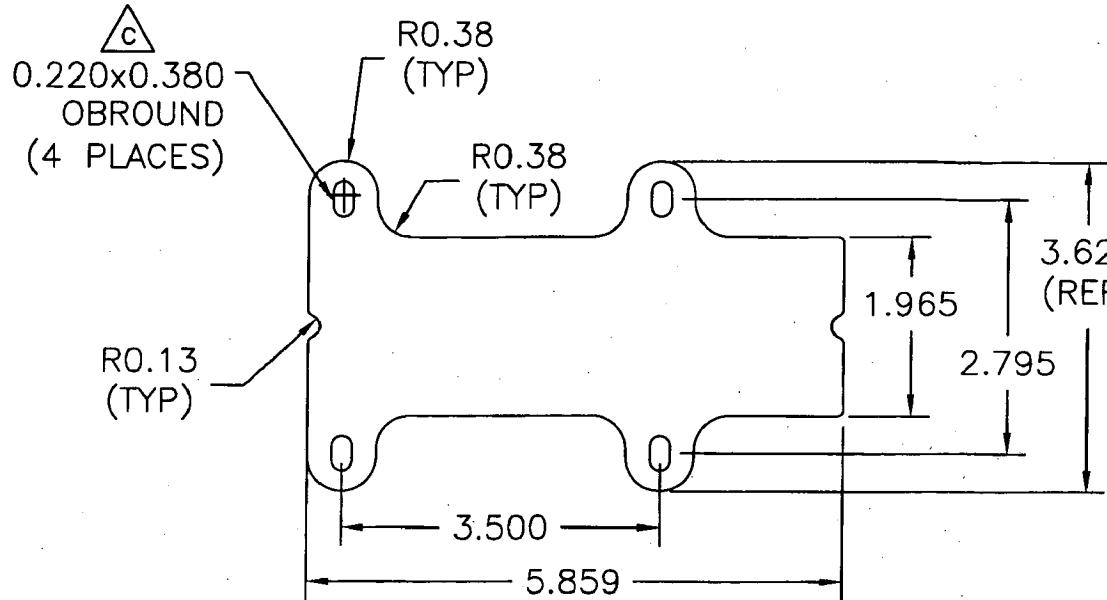
Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-10-27	Date:	08/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>

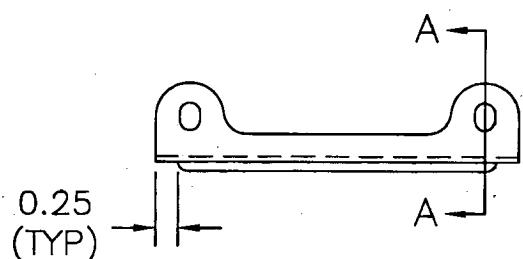
D3537-1F FLAT PATTERN



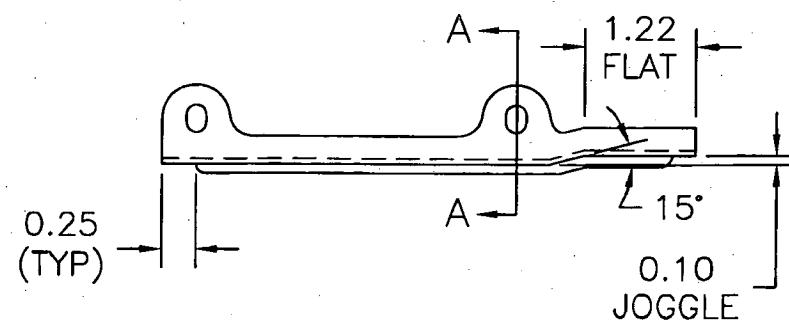
D3537-3F FLAT PATTERN



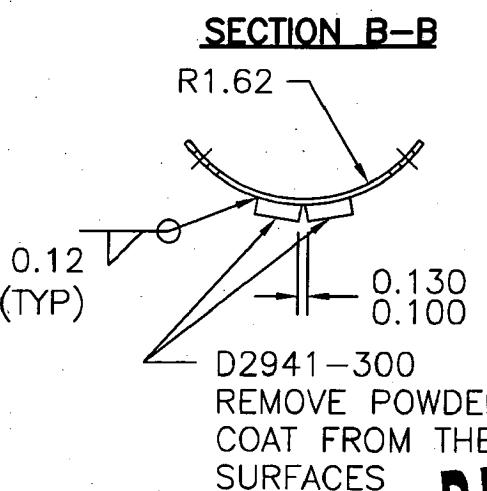
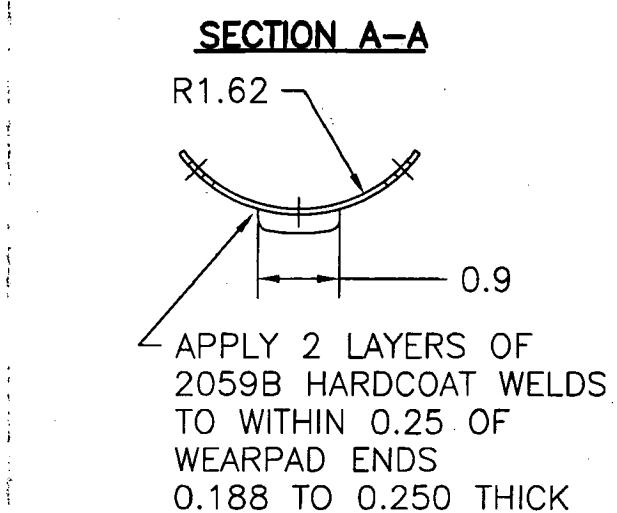
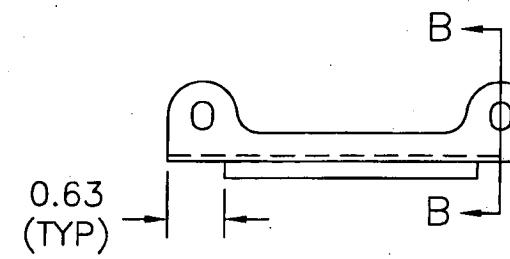
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)

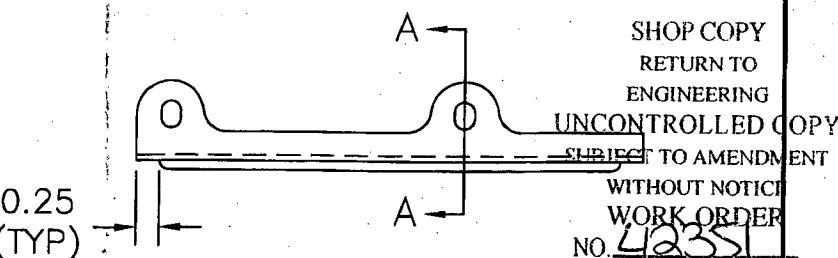


D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



RELEASED
07.05.08 AM
per ELN

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
C.B	P.H.	
CHECKED	APPROVED	DRAWING NO.
#	#	D3537
DATE		SHEET 1 OF 1
07.04.13		SCALE
		1:2
	TITLE	WEARPAD

